

Date: Friday, 6/1/2007 1:02:51 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GASKET		
Job Number	: 32746					
Estimate Number	: 12722					
P.O. Number	: N/A		Part Number	: D353615		
This Issue	: 6/1/2007	S.O. No. : N/A	Drawing Number	: D3536 REV A		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: A		
Previous Run	: 31994		Material	: N/A		
Written By			Due Date	: 6/8/2007 Qty: 20 Um: Each		
Checked & Approved By						
Comment	: Est Rev A		New Issue 07-02-14 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MNEO60S063	NEOPRENE SHEET 0.063	
		Comment: Qty.: 1.0340 sf(s)/Unit Total : 20.6808 sf(s) NEOPRENE SHEET 0.063 Batch: ml 01 06 03	(Go)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A ml 07 06 03	(Go)
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		ml 07 06 04	(Go)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	SD 07.06.04 (Go)
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	EJ 07/06/04 (Go)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 6/1/2007 1:02:51 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32746

Part Number: D353615

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(28)

Comment: FINAL INSPECTION/W/O RELEASE

6/1/07/05

Job Completion



C20706/04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32746
Description: Gasket	Part Number:	D3536-15
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.15	✓		M+	
35.65	+/-0.030	35.65	✓		M.T	
33.65	+/-0.030	33.65	✓		M.T	
30.15	+/-0.030	30.15	✓		M.T	
24.90	+/-0.030	24.90	✓		M.T	
19.65	+/-0.030	19.65	✓		M+	
14.40	+/-0.030	14.40	✓		M.T	
9.15	+/-0.030	9.15	✓		M.T	
5.65	+/-0.030	5.64	✓		M+ V/N	
3.90	+/-0.030	3.89	✓		V/N	
8.00	+/-0.030	8.00	✓		M+	
16.00	+/-0.030	16.00	✓		M.T	
24.00	+/-0.030	24.00	✓		M.T	
0.30	+/-0.030	0.300	✓		V/N	
0.30	+/-0.030	0.300	✓		V/N	
1.89	+/-0.030	1.88	✓		V/N	
Ø0.19	+0.005/-0.001	0.19	✓		V/N	

Measured by:	m/m
Date:	01.06.04

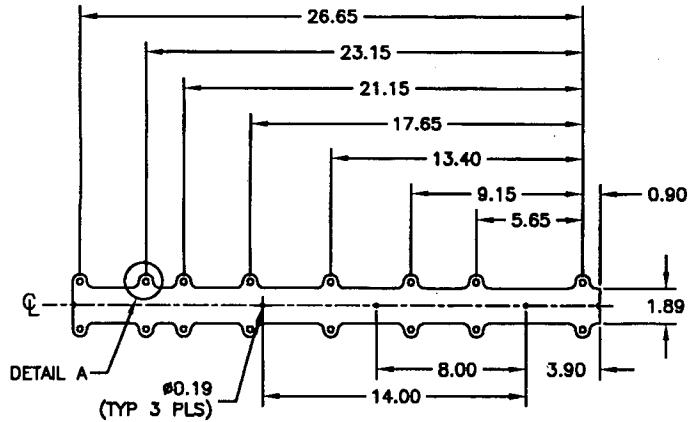
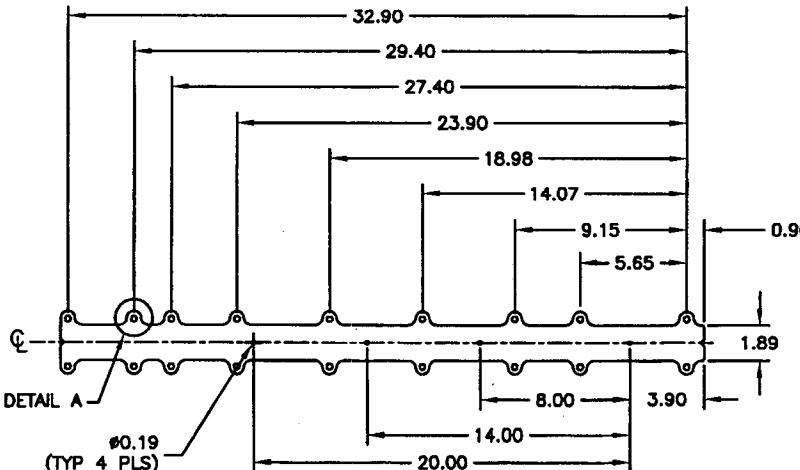
Audited by:	SA
Date:	01.06.04

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	JL

DART

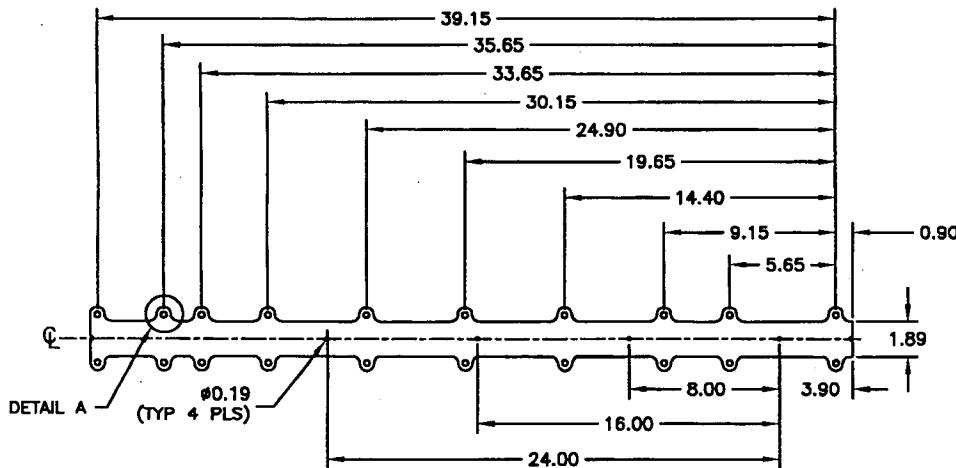
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**D3536-11 GASKET****D3536-13 GASKET**

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C B	C B	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
M	S	D3536
DATE		TITLE
06.10.25		GASKET
A	06.10.25	NEW ISSUE

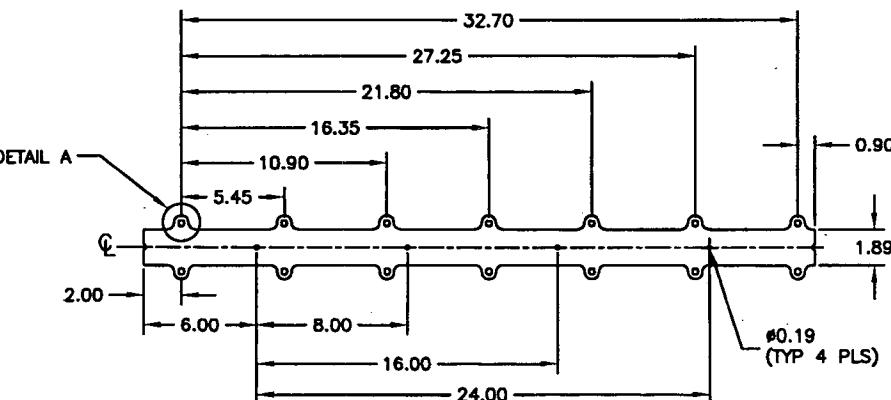
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WITHOUT NOTICE
WORK ORDER
NO. 32746

- NOTES
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT Q
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

DART07.02.12
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DART**D3536-15 GASKET**

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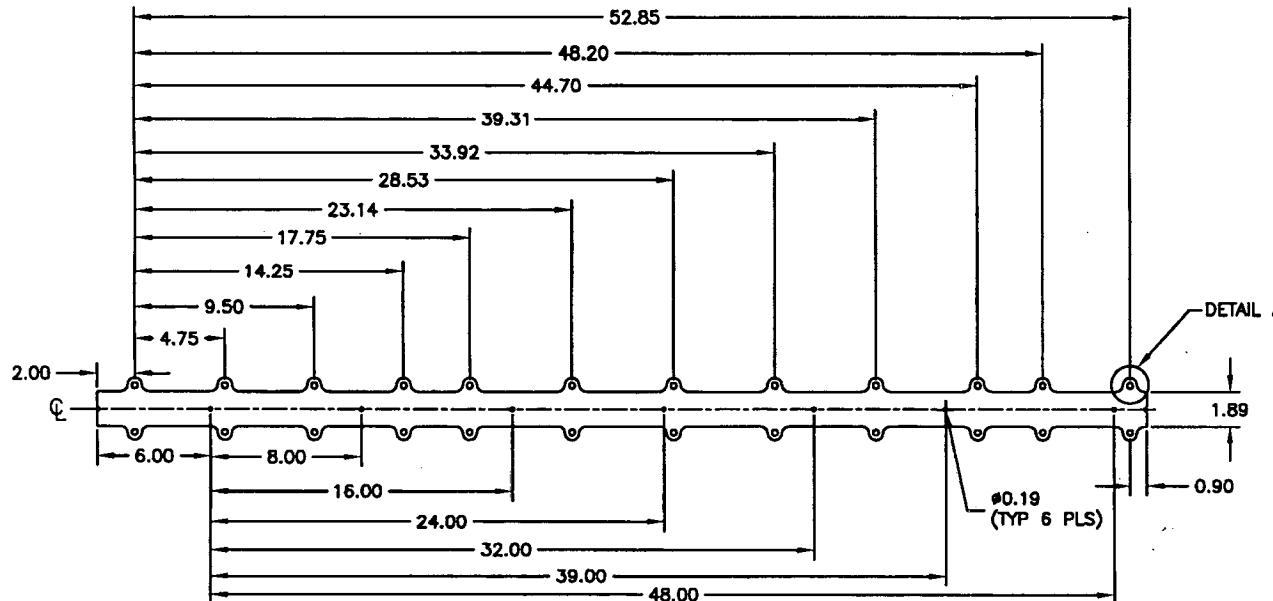
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 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

**D3536-21 GASKET**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PRT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>MH</i>	<i>MH</i>	D3536
DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 2 OF 6
		SCALE
		1:10

DART

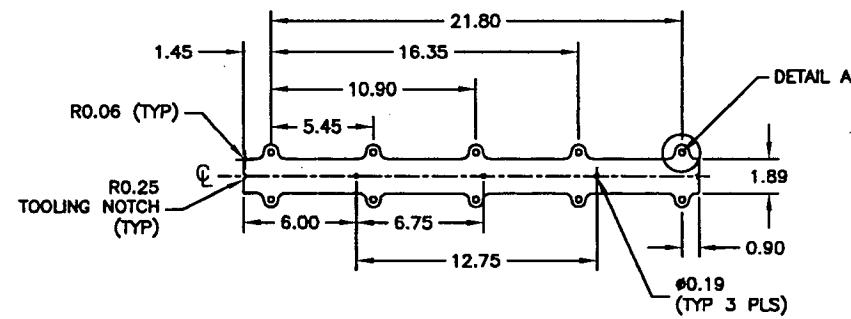
PART NUMBER
07-02-12



D3536-23 GASKET

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WORK ORDER
NO. 2146

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

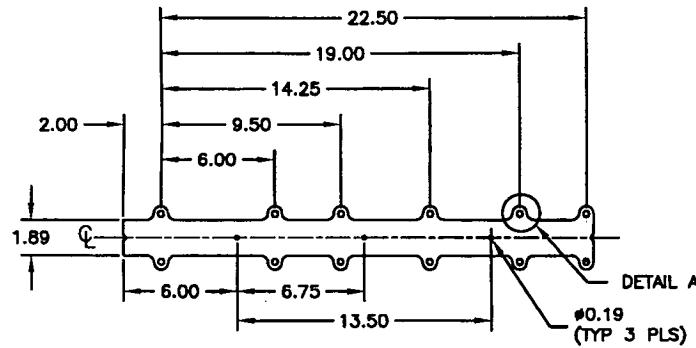
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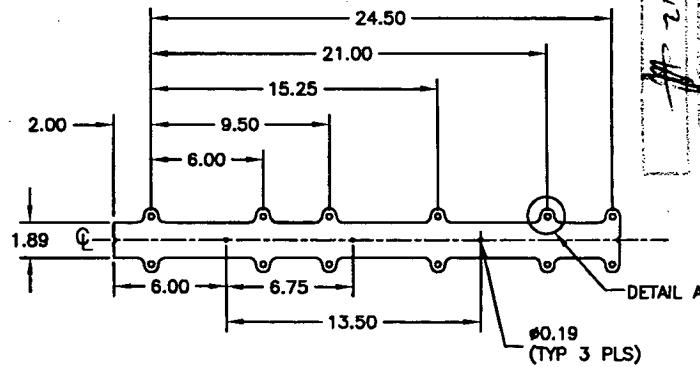
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<i>MH</i>	<i>JM</i>	D3536
DATE	TITLE	SCALE
06.10.25	GASKET	1:10

DART

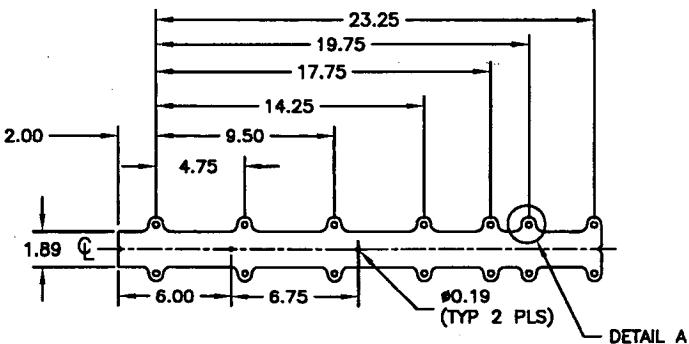
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D3536-31 GASKET



D3536-33 GASKET



D3536-35 GASKET

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DATE 06.10.25	TITLE GASKET	SHEET 4 OF 6 SCALE 1:10

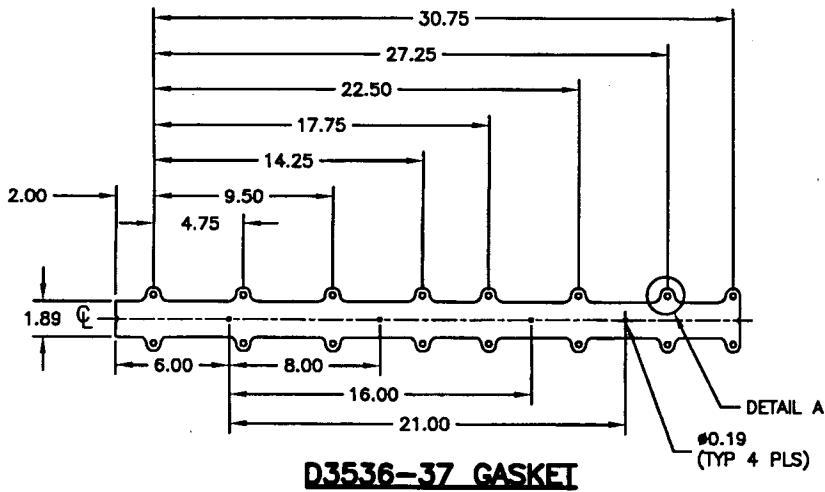
- NOTES**
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 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

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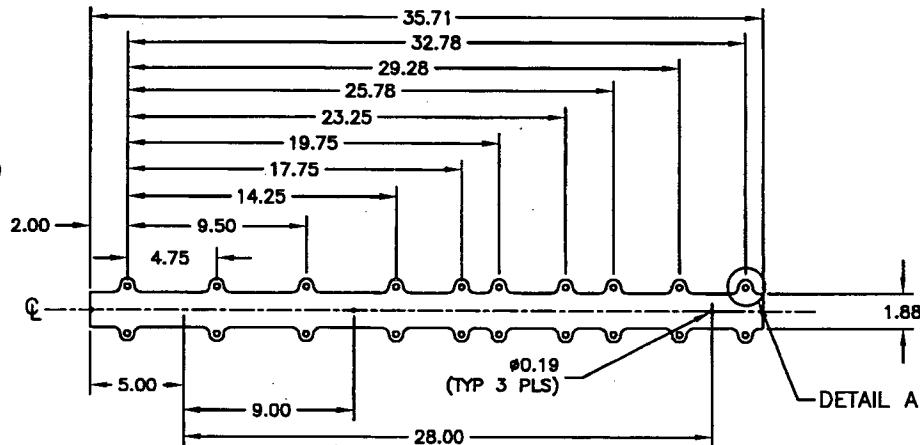
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DATE 06.10.25	TITLE GASKET	SHEET 5 OF 6 SCALE 1:10

07.02.02
MH

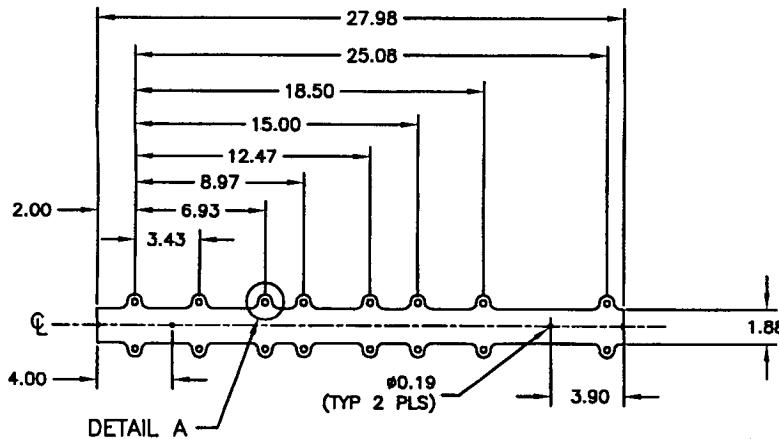
**D3536-37 GASKET****NOTE:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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**D3536-39 GASKET**

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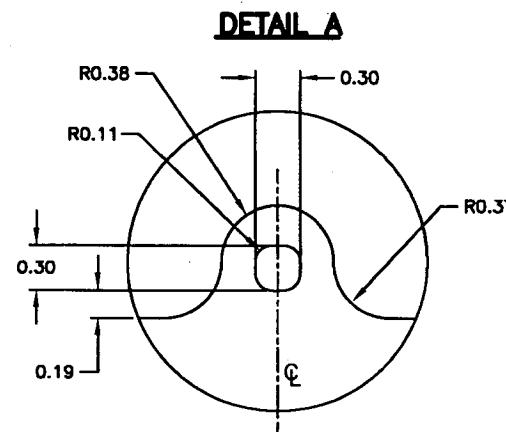
D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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CHECKED	APPROVED	DRAWING NO.
P/H	H	D3536
DATE		SCALE
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